

What is claimed is:

1. A method for controlling the curl of a web of paper or paperboard, the method comprising the steps of

5 - forming a base web,
 - drying the base web on the press section of the papermaking machine,
 - drying the base web further on the dryer section of the papermaking
 machine,
 - setting a base web speed differential, or draw, between the press section and
10 the first dryer cylinder group of the dryer section,
 - surface sizing at least one surface of the web,
 - the draw is set to 3 % maximum, and
 - a surface size furnish is applied having a solids content of at least 15 % of
 the total amount of size components and liquid in the furnish,
15 characterized in that
 - in the size furnishes applied to the two sides of the web, the ratio of dry
 solids to the size components and liquid are different from each other.

2. The method of claim 1, characterized in that the amounts of size furnish applied
20 to both sides of the web are equal but the amounts of water imported to the two sides
 of the web are different.

25 3. The method of claim 1, characterized in that the amounts of size furnish applied
 to both sides of the web are different but the amounts of water imported to the two
 sides of the web are equal.

30 4. The method of claim 1, characterized in that both sides of the web are treated
 and to at least one side of the web is applied a surface size furnish wherein the
 proportion of size components in the total amount of size components and liquid is at
 least 15 % and the ratio of size solids to the total amount size and liquid in the size
 furnish applied to the two sides of the web are different from each other.

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4. The method of claim 1 or 3, characterized in that a surface size furnish is used wherein the proportion of size components in the total amount of size components and liquid is at least 20 %, advantageously 25 %.
5. The method of claim 1, characterized in that the draw is set to 1 - 2%.
6. The method of any one of foregoing claims, characterized in that a brightener is added to the size furnish.

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